

Work Order ID 65340

January 12, 2011 11:44:50 AM



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Item ID: D412-711-101

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Bubble Window

Start Date: 1/12/11 Start Qty: 2.00



Cust Item ID:

Required Date: 1/26/11 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: CLDate: 1/10/12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D412-711-101

A

100

0.00



DC

Document Control

Memo

Photocopy bluefiles and create labels
for PPP D412-711-101 Change 002

0.00

*Sulokis**H. de MF 11-01-18*

110

0.00



HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

Set up Machine as per folio FTA 077 and D711W program using mould DT9640

0.00

H. de 11/01/17

120

0.00



HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

Cut Blanks to 36" by 39"

0.00

H. de 11/01/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo Thermoform as per Dwg. D412-711-101 using DT 9640 and Folio FTA 077 <u>A</u> Dwg. Rev. <u>A</u> Folio Rev.	0.00 0.00							<u>SL</u> 11/01/17
140 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo 1) Check Surface finish for undesired marks, voids, dimples etc. 2) Check depth of bubble to ensure conformity to drawing tolerances.	0.00 0.00							<u>SL</u> 11/01/17
150 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				2			<u>B</u> 11/01/17

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandThermo	HAND FINISHING THERMOFORMING	0.00							
Hand Finishing Thermoforming	Memo 1) Trim off excess flange material 2) Buff out any light scratches or 3) Etch part number and batch number	0.00				2			B 11/01/17
170 QC	QC2- Inspect parts off machine FAI/FAIB	0.00							
Quality Control	Memo 1) Visually inspect for clarity, and proper formation.	0.00				2			B 11/01/17
180 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo 1) Visually inspect for clarity, and proper formation.	0.00				2			8/16/18

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Start Date: 1/12/11 Start Qty: 2.00



Cust Item ID:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

185

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Subaru

(x2)

Quality Control

190

Identify as per dwg & Stock Location: 91

0.00



Packaging

Memo

0.00

Rev c

11/1/19 SP

(20)

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/19 SP

MF

11-01-19

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Picklist Print

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Page 1

Work Order ID: 65340



Parent Item: D412-711-101



Parent Item Name: Replacement Bubble Window

Start Date: 1/12/11

Required Date: 1/26/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-02-01 JLM
Manufacture in-house 10/06/28 DL

IPP Rev. B.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MACRLICS.236

Purchased

No

sf

208.0000

16

32



Plexiglass G .236"

Location

Loc Qty

Loc Code

therm

208

115590

8

116030

200

DL
11/01/18

40 sq ft.

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	65340
Description: Replacement Window		Part Number:	D412-711-101
Inspection Dwg: D412-711-101 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>JB</u>	Date: <u>11/01/17</u>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	+/-0.030	1.975	✓			
1.73	+/-0.030	1.75	✓			
1.98	+/-0.030	2.0	✓			
1.50	Min	1.6	✓			
0.090	Min	.097	✓			
0.070	Min	.088	✓			
0.050	Min	.084	✓			
15.0	+/-0.5	15.250	✓			

Measured by: <u>JB</u>	Date: <u>11/01/17</u>
Audited by: <u>S</u>	Date: <u>11/01/18</u>
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.10.08	New Issue	KJ	

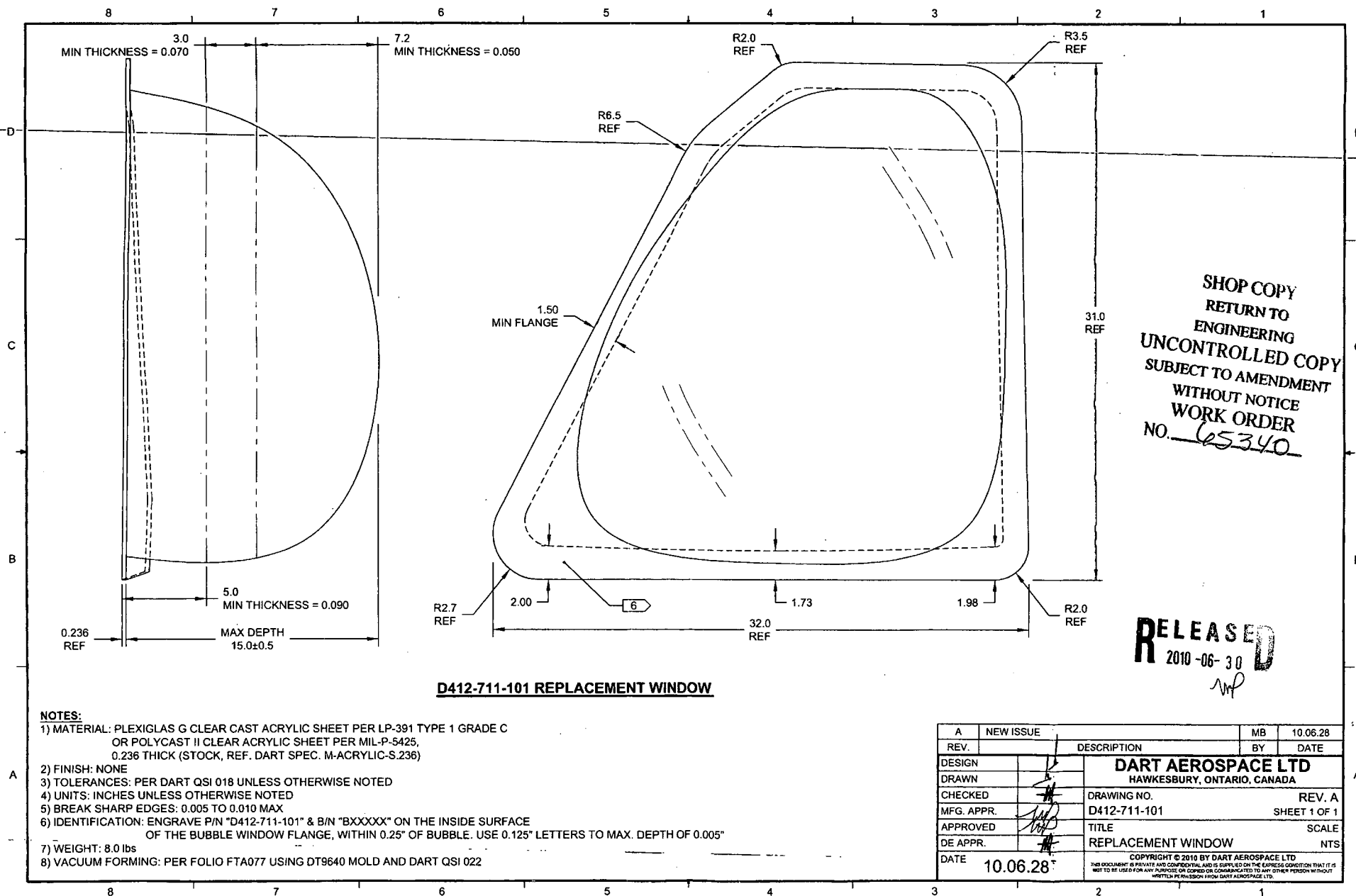
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